

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021709**Date Inspected:** 24-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhan Hai Feng CWI QA Bao Qiam.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13CE

PCMK: DP3102-001

Weld No: 049

Welder: 052696

WPS-B-T-2233-ESAB

Components; OBG 13CE (see photo below)

PCMK: SEG3011G

Weld No: 008

Welder: 037705

WPS-B-T-2232-ESAB

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Components; OBG 14E
PCMK: SEG3019L
Weld No: 200, 301, 303, 305
Welder: 051356
WPS-B-P-2233-ESAB

Components; OBG 13AE
PCMK: SEG3007P
Weld No: 024
Welder: 055564, 055491
WPS-B-T-2232-ESAB

Components; OBG 14AE
PCMK: SEG3007AH
Weld No: 025, 027
Welder: 050242
WPS-B-P-2233-ESAB

Components; OBG 14BE
PCMK: SEG3007AT
Weld No: 011,012
Welder: 0020009
WPS-B-P-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhan Hai Feng CWI QA Bao Qiam.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E
PCMK: DP3163-001
Weld No: 216, 218
Welder: 215553
Repair No. WR20222
WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 14E
PCMK: DP3164-001
Weld No: 020
Welder: 050969
Repair No. WR20222
WPS-345-SMAW-2G(2F)-FMC-Repair-1

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Components; OBG 14E
PCMK: DP3161-001
Weld No: 212,213
Welder: 037932
Repair No. WR20250
WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 14E
PCMK: DP3167-001
Weld No: 041
Welder: 067656
Repair No. WR20271
WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 14E
PCMK: SEG3019R
Weld No: 158, 159
Welder: 067610
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14E
PCMK: SEG3019U
Weld No: 003
Welder: 054013, 066418, 044779
Repair No. B-WR20270
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14AE
PCMK: SEG3007B
Weld No: 140
Welder: 216086
WPS-B-P-2213-B-U2-FCM-1

Components; OBG 14BE
PCMK: SEG3007E
Weld No: 066
Welder: 068924
Repair No. B-WR20179
WPS-345-SMAW-2G(2F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Li Ping, CWI An Qing Xiang.

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Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG
PCMK: SEG3020Y
Weld No: 022
Welder: 047864
Weld Repair No. B-CWR2792
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG
PCMK: DP3173-001
Weld No: 020
Welder: 066480
Weld Repair No. B-WR20289
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG
PCMK: DP3172-001
Weld No: 018
Welder: 037780
WPS-B-P-2212-TC-U4b-FCM

Components; OBG
PCMK: SEG3020Z
Weld No: 005,004
Welder: 067609, 067764, 066038
WPS-B-P-2214-TC-U5-FCM-1

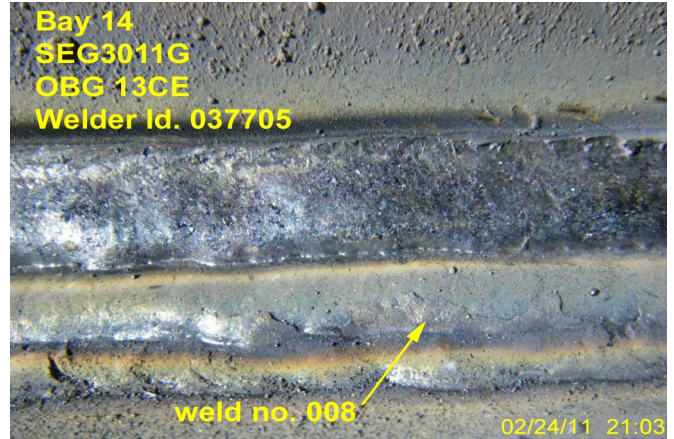
This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Li Ping, CWI An Qing Xiang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG
PCMK: SEG3020BB
Weld No: 110
Welder: 067949
WPS-B-T-2233ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer